

Date: Monday, 6/5/2006 7:34:16 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOOR ASSEMBLY		
Job Number	: 27340A					
Estimate Number	: 11454					
P.O. Number	: N/A		Part Number	: D41269401		
This Issue	: 6/5/2006	S.O. No. : N/A	Drawing Number	: D412-694		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: C1		
Previous Run	: 27323A		Material	: N/A		
Written By			Due Date	: 7/15/2006 Qty: 1 Um: Each		
Checked & Approved By						
Comment	: Est Rev: A 05.12.09 New Issue KJ/RF Est. Rev B New dwg rev. ecn781 06.04.18 EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL 
Comment: DOCUMENT CONTROL Issue red decal labels for D412-694-01		CHG005
2.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY 
<b>Comment: COMPOSITE ASSEMBLY</b> D412-694-01 Drill Process ✓ 1- Drill (7) holes using Ø(#40) drill. Drill (3) holes top/bottom Ø(#40) for insert (do not pass thru) using B30-23000-01 as per Dwg D412-694 page 4 (view P).  ✓ 2- Open (1) hole to 11/16" (0.688) for the handle using unibit. Transfer (4) Ø(#30) holes from D3151-041 to the door and c'sink from far side for the rivet. Transfer (2) holes Ø(3/16") for MS24694-C5 screw as per Dwg D412-694 page 4 (view P). Note: D3151-041 orientation in the door.  ✓ 3- Open (3) holes Ø(#19) or (0.166) top/bottom of the door and c'sink Ø0.300 x 100° from the far side and D3155-041/-042 bracket assembly as per Dwg D412-694 page 4 (view P).  ✓ 4- Drill Ø(#30) holes using drill Jig D3144-T1 for the doublers. Drill (2) holes in two places Ø 3/16" (0.188) for the slot opening. Router slot using D3144-T2/-T3 as per Dwg D412-694 page 2. Note: The (12) holes for the (6) nut plates can not be less than 0.290" from inside edge.  ✓ 5- Open (3) holes to Ø37/64" (0.578) at top/bottom insert for D3163-041 cover assembly as per Dwg D412-694 page 4 (view P). Drill Ø(#30) outer door handle as shown in view Z-Z page 2. Open holes to Ø0.257.  ✓ 6- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-1. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view K, L, M, Q).		

W/O:		WORK ORDER CHANGES							
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			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Description :

- ✓ 7- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-2. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view H, J).
- ✓ 8- Drill (27) pilot holes Ø(#30) using drill Jig DT8703-3LH for D3126 brackets as per Dwg D412-694 page 2 (view G-G). Use unibit to open holes Ø37/64" (0.578) for inserts.
- ✓ 9- Drill (2) Pilot holes Ø(#30) by transfer from D3152-041 bracket. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 6 (view Q).
- ✓ 10- Drill (12) Ø(#30) holes from the edge of the door to opposite side for D3162-041 bracket using a long drill and keep drill perpendicular. Ensure (4) holes used from the center of the hole to top and bottom edge of the thick section of D3163-041 cover assembly. Compare hole depth with rivet in the foam as per Dwg D412-694 page 4 (view P) and (view R-R-S-S). Drill (8) Ø(#30) holes from the edge of the door using a long drill and keep drill perpendicular. About the (4) last holes around the small square of the cover, take the measurement 0.250" from each corner of the D3163-041 cover.

ml07/10/12

3.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

removed. ml07/10/12

ml07/10/12

4.0 8000528

Insert



Comment: Qty.: 55.0000 Each(s)/Unit Total : 55.0000 Each(s)

Insert

Batch

M15893

A/R Hysol EA934NA

M104835

Expiry Date:

17 May 2008

ml

ml

5.0 COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1-Install inserts as per Dwg D412-694 page 2 (view G-G); page 6 (view H, J, L, M, Q).

2- Sand flush excess Hysol around the insert on both doors.

ml07/10/15

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect that inserts are flush with the surface.

10.10.15 ①

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Seq. #: Machine Or Operation:

Description :

7.0 SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

BT 07-10-16

8.0 QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

ES 09/10/16

9.0 D31105

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle

B27081

✓ ml

10.0 D31151

Bracket



JP.



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

D24696-

11.0 D31167

Seal ZX2054



JP.



Comment: Qty.: 5.6666 f(s)/Unit Total : 5.6666 f(s)

Seal ZX2054

Batch

B27239-

PTO

12.0 D31169

Seal ZX1267



JP.



Comment: Qty.: 6.4166 f(s)/Unit Total : 6.4166 f(s)

Seal ZX1267

Batch

B17463-

= 76.500

13.0 D3121041

Bracket Assembly



JP.



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bracket Assembly

Batch

821677 B27367-

JP. 07/09/180

W/O:		WORK ORDER CHANGES						
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07/10/15	12	Stone did not read FS. They read B.4166 F missing 4 inches of seal	OSUAR	Scrap seal 6.4166 F. take in box 6.466 F(s) Put note on box do not cut they are already cut at the good length.	07/10/15	07/10/15	OSUAR	07/10/15

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No DQA:  Date: 07/10/15

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Job Number:



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Description :

14.0 D3121043 Bracket Assembly



*[Signature]*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

B24678

15.0 D31221 Lever



*[Signature]*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

B25539

16.0 D31231 Cam



*[Signature]*



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cam

Batch

M10536-17

17.0 D31241 Hook



*[Signature]*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hook

Batch

M10536-17

18.0 D31242 Hook



*[Signature]*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hook

Batch

M10536-17

19.0 D31261 Bracket



*[Signature]*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

B25419

20.0 D31263 Bracket



*[Signature]*



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

B28105

*[Signature] 6/9/18 ①*

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Description :

21.0 D31265 Bracket



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket

B18658

22.0 D31271 Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacer

Batch

617784

23.0 D3132041 Rod Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod Weldment

Batch

M10536-17

24.0 D3133042 Rod Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod Weldment

Batch

M10536-17

25.0 D3135041 Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch

B19861

26.0 D3137045 BRACKET ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET ASSEMBLY

Batch

B27339

27.0 D31381 Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover

Batch

B25178

W/O:		WORK ORDER CHANGES						
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Job Number:



Seq. #: Machine Or Operation:

Description :

28.0 D31391 Guard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Guard  
Batch

B24700

29.0 D31393 Guard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Guard  
Batch

B24700

30.0 D314005 Door Kit



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)  
Door Kit  
Batch

B27340A

ml 07/10/10

31.0 D31411 Spring #204-032-734-001



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Spring #204-032-734-001  
Batch

B34725

ml 07/10/10

32.0 D31443 Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Doubler  
Batch

B18816

33.0 D314413 Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Doubler  
Batch

B24723

34.0 D3144109 Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Doubler  
Batch

B23145

EP 07/09/18 ①

W/O:		WORK ORDER CHANGES							
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Job Number:



Seq. #: Machine Or Operation:

Description :

35.0 D3144111 Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

B27380

36.0 D31481 Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clevis

Batch

M10536-17

37.0 D3151041 Doubler Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler Assembly

Batch

B24685

38.0 D3152041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

B18867

39.0 D3155041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

B24666/B27178

40.0 D3155042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

B26933

41.0 D31561 Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket

Batch

B24706(1) B24772(1)

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Drawing Name: DOOR ASSEMBLY

Job Number: 27340A

Part Number: D41269401

Job Number:



Seq. #: Machine Or Operation:

Description :

42.0 D3162041 Bracket Assembly



*GP*

Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bracket Assembly  
Batch B24688-

43.0 D3162043 BRACKET ASSEMBLY



*GP*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly  
Batch B27348-

44.0 D3162044 BRACKET ASSEMBLY



*GP*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly  
Batch B24452-

45.0 D3163041 Cover Assembly



*ml*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover Assembly B27349

46.0 D3183041 Bracket Assembly



*✓ ml*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly  
Batch B21893

47.0 D32031 Handle



*✓ ml*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle  
Batch B24956A

48.0 D33081 Doubler



*GP* *GP 07/09/18 Q*

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Doubler  
Batch B21912-

W/O:		WORK ORDER CHANGES						
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Drawing Name: DOOR ASSEMBLY

Job Number: 27340A

Part Number: D41269401

Job Number:



Seq. #: Machine Or Operation:

Description :

49.0 AN52510R6 Screw



*JP.*



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Batch

*M15943-*

50.0 AN52510R7 Screw



*JP.*



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

Batch

*M104214*

51.0 AN960JD8 Washer



*JP.*



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

*M104374*

52.0 AN960JD10L Washer



*JP.*



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch

*M103044*

53.0 AN960JD10LL Washer



*JP.*



Comment: Qty.: 15.0000 Each(s)/Unit Total : 15.0000 Each(s)

Washer

Batch

*M119600*

54.0 AN960JD416L Washer



*JP.*



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

*M105408*

55.0 BSP45 Commercial Rivet



*JP.*



Comment: Qty.: 79.0000 Each(s)/Unit Total : 79.0000 Each(s)

Commercial Rivet

Batch

*M11821*

*JP. 07/09/180*

W/O:		WORK ORDER CHANGES							
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Seq. #: Machine Or Operation:

Description :

56.0 BSP46 Commercial rivet



*JP.*



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Commercial rivet

Batch

*M109098-*

57.0 M7885243 CCR3213-4-03 Rivet



*JP.*



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet

Batch

*M144177*

58.0 MS203922C9 Pin



*JP.*



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

*M11784-*

*JP.*



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

*M1735(1X)*

*M18949(1X)-*

59.0 MS203922C17 Pin



*JP.*



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

*M11765*

*JP.*



60.0 MS203923C21 Pin



*JP.*



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

*M11765*

*JP.*



61.0 MS20426AD33 Rivet



*JP.*



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rivet

Batch

*M1563-*

*JP.*



62.0 MS20426AD45 Rivet



*JP.*



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

Batch

*M13459-*

*JP.*



W/O:		WORK ORDER CHANGES							
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Part Number: D41269401

Job Number:



Seq. #: Machine Or Operation:

Description :

63.0 MS20426AD4 Rivet



PTO

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)  
Rivet  
Batch M112655

64.0 MS21042L4 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Nut  
Batch M104248

65.0 MS21042L08 Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Nut  
Batch M104812

66.0 MS21072L3 Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Nutplate  
Batch M18728

67.0 MS24665151 Cotter Pin



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Cotter Pin  
Batch M14526

68.0 MS24693S271 Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Screw  
Batch M14478

69.0 MS24694C5 Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Screw  
Batch M11755

GP 07/09/180

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
07/10/18	63	See <u>6A</u> changes Rivets ms 20426 AD 4-7 For <u>M 7885/3-4</u> <u>(X12)</u> <u>m104625</u> Put ms 20426 AD 4-7 back in store			ml	07/10/18		<u>AA</u> 07/10/18	<u>/</u> 07-10-23

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:34:18 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340A

Part Number: D41269401

Job Number:



Seq. #: Machine Or Operation:

Description :

70.0 MS24694S5 Screw



*GP*

Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Screw

Batch

*M18949*

71.0 MS24694S50 Screw



*GP*

Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Screw

Batch

*M104625*

72.0 MS24694S98 Screw



*GP*

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

*M104156*

73.0 MS27039105 Screw



*GP*

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

*M3501*

74.0 MS27039106 Screw



*GP*

Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Screw

Batch

*M11754*

75.0 MS27039108 Screw



*GP*

Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Screw

Batch

*M104215*

76.0 MS35275233 Screw



*GP*

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

*M11822*

*GP 07/09/180*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector		
			Initial Design Mgr	Action Description Design Mgr	Sign & Date					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Dates: Monday, 6/5/2006 7:34:18 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340A

Part Number: D41269401

Job Number:



Seq. #:	Machine Or Operation:	Description :
77.0	MS35649264	Nut
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Nut	<u>M11822</u>
	Batch	
78.0	MS356503252	Nut
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Nut	<u>M11735</u>
	Batch	
79.0	MS518597	Washer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Washer	<u>M11822</u>
	Batch	
80.0	NAS43DD310	Spacer
	Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)	
	Spacer	<u>M19347</u>
	Batch	
81.0	NAS43DD314	Spacer
	Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)	
	Spacer	<u>M19347</u>
	Batch	
82.0	COMPOSITE ASSY	COMPOSITE ASSEMBLY

Comment: COMPOSITE ASSEMBLY

D412-694-01 Assembly Process

- ✓ 1- Install D3162-041 as per Dwg D412-694 page 4 (view R-R/S-S) and D3156-1 bracket as per (view T-T/U-U). Open holes to #30 (0.128) for rivet and alodine the open holes.

Note: Start installation window side. Wait to fix D3162-041/-043.

- ✓ 2- Install D3151-041 Doubler as per Dwg D412-694 page 4 (view P).

- ✓ 3- Connect D3132-041 Rod Weldment with D3122-1 Lever and D3133-041 Rod Weldment as per Dwg D412-694 page 4 (view P).

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:34:18 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 4- Assemble D3123-1 Cam with D3124-1/-2 Hook with D3155-041/-042 Bracket Assembly as per Dwg D412-694 page 4 (view P).

✓ 5- Install D3203-1 handle with D3308-1 doubler as per Dwg D412-694 page 2 (view Z-Z).

✓ 6- Install D3155-041/-042 Bracket Assembly and D3110-5 Handle as per Dwg D412-694 page 4 (view P) and page 2. Adjust rod weldment until everything works properly and looks in place.

ml 07/10/16

83.0

QC5

INSPECT WORK TO CURRENT STEP



*A-A-183* (1)



Comment: INSPECT WORK TO CURRENT STEP

84.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-01 Assembly Process (Continued)

1- Install D3116-7-0680 Seal and doublers. Transfer slot opening in the seal as per Dwg D412-694 page 2 (view V-V and N).

Note: If this is the D412-694-013, wait until the VIP trim is fixed on the door.

2- Install D3110-5 Handle Assembly in the D3163-041 Cover Assembly. Ensure Handle works freely. Ensure D3163-041 cover assembly is aligned with the door edge on both sides and D3110-5 Handle works properly.

3- Transfer the holes to the cover with the hole finder. EXCEPTION: the (4) holes around the handle. Install the bracket with the holes from the small square of the cover ( $\varnothing 0.250"$ )

4- Open 15/64" (0.234) holes to D3163-041 cover assembly and D3135-041 handle weldment. Transfer D3139-1/-3 guard holes in cover assembly and drill holes for nutplate. Deburr and touch up holes with alodine as per Dwg D412-694 page 2.

5- Install MS21072-L3 Nutplate and Guard as per Dwg D412-694 page 2.

6- Transfer (#30) holes from D3144-13 doubler to seal and door. Ensure D3116-9-0770 is properly aligned as per Dwg D412-694 page 2 (section NN-NN). Apply 732 RTV Clear (A/R) in the hole prior to installing rivet and then in the rivet head after installation.

7- Install D3126 Brackets and D3138-1 Cover as per Dwg D412-694 page 2 (view G-G and NN-NN).

8- Install and assemble brackets as per Dwg D412-694 page 2 and 5 (view H, J, L, M and Q).

ml 07/10/18

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:34:18 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 27340A

Part Number: D41269401

Job Number:



Seq. #: Machine Or Operation:

Description :

(PTO)

85.0 QC5

INSPECT WORK TO CURRENT STEP



07-10-23 (1)



Install on Air Craft.

Comment: INSPECT WORK TO CURRENT STEP

86.0 COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

- 1- Finish installing D3163-041 in the door.
- 2- Install red decal before closing cover.

ml 07/10/23 (1)

87.0 QC5

INSPECT WORK TO CURRENT STEP



07-10-23 (1)



Comment: INSPECT WORK TO CURRENT STEP

Install door on mock up helicopter to insure proper fit and function.

88.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: —

C 07/10/24 (1)

89.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

F 07/10/25

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
11-10-23	85.0 <u>87.0</u>	Swap Step 87.0 for 85.0. Perm.Change						11-10-23	11-10-23

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

RELEASED

0-10-2015

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X				D412-694-01	DOOR ASSEMBLY
X				D412-694-02	DOOR ASSEMBLY
X				D412-694-03	DOOR ASSEMBLY
X				D412-694-04	DOOR ASSEMBLY
1	1			D3110-1	ESCUTCHEON
				D3110-3	HANDLE
1	1			D3110-5	HANDLE ASSEMBLY
				D3110-6	PLATE ASSEMBLY
2	2			D3112-1	GUIDE
1	1			D3113-1	SPRING
1	1			D3114-1	PIVOT
1	1			D3115-1	BRACKET
				D3116-11-0180	SEAL
1	1			D3116-5-0600	SEAL
1	1			D3116-7-0600	SEAL
1	1			D3116-9-070	SEAL
				D3119-041	COVER ASSEMBLY
				D3119-042	COVER ASSEMBLY
				D3120-1	COVER
				D3120-2	COVER
				D3120-3	COVER
				D3120-4	COVER
3	3			D3121-041	BRACKET ASSEMBLY (ROLLER)
				D3121-043	BRACKET ASSEMBLY (ROLLER)
				D3121-044	BRACKET ASSEMBLY (ROLLER)
1	1			D3122-1	LEVER
2	2			D3123-1	CAM
1	1			D3124-1	HOOK
1	1			D3124-2	HOOK
				D3125-1	LEVER
				D3125-3	LEVER
				D3125-5	LEVER
				D3125-7	LEVER
1	1			D3126-1	BRACKET (SLIDER)
1	1			D3126-3	BRACKET (SLIDER)
5	5			D3126-5	BRACKET (SLIDER)
1	1			D3127-1	SPACER
				D3128-1	SHIM
				D3129-1	LEVER
				D3130-1	CLEVIS BASE
				D3131-1	STOP
1				D3132-041	ROD WELDMENT
				D3132-042	ROD WELDMENT
				D3133-041	ROD WELDMENT
1				D3133-042	ROD WELDMENT
				D3134-1	ROD
				D3134-3	ROD
1	1			D3135-041	HANDLE WELDMENT
1	1			D3137-045	BRACKET ASSEMBLY
1				D3138-1	COVER
1				D3138-2	COVER
1	1			D3139-1	GUARD
				D3139-3	GUARD
1				D3139-4	GUARD
1				D3140-005	DOOR
-1				D3140-006	DOOR
				D3140-07	DOOR
				D3140-08	DOOR
2	2			D3141-1	SPRING
				D3143-1	CLEVIS
3	3			D3143-3	CLEVIS
1				D3144-1	DOUBLER
				D3144-3	DOUBLER
1				D3144-105	DOUBLER
				D3144-107	DOUBLER
1				D3144-109	DOUBLER

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
1	1			D3144-111	DOUBLER
	1			D3144-115	DOUBLER
		1		D3144-117	DOUBLER
		1		D3144-121	DOUBLER
		1		D3144-119	DOUBLER
1	1			D3144-123	DOUBLER
		1		D3144-13	DOUBLER
		1		D3145-1	HINGE BRACKET
		1		D3145-2	HINGE BRACKET
		1		D3145-1	HINGE BRACKET
		1		D3146-2	HINGE BRACKET
2	2			D3147-1	PIN
	2	2		D3148-1	CLEVIS
	2	2		D3149-1	STRIKER PLATE
	2	2		D3150-1	GUIDE
1	1			D3151-041	DOUBLER ASSEMBLY
1				D3152-041	BRACKET ASSEMBLY
		1	1	D3154-1	KEY
	1	1		D3155-041	BRACKET ASSEMBLY
1	1			D3155-042	BRACKET ASSEMBLY
2	2			D3155-1	BRACKET
	2	2		D3157-1	SPACER
3	3			D3159-041	BRACKET ASSEMBLY
	1			D3159-043	BRACKET ASSEMBLY
	1			D3159-044	BRACKET ASSEMBLY
10	10			D3162-041	BRACKET ASSEMBLY
1	1			D3162-043	BRACKET ASSEMBLY
1	1			D3162-044	BRACKET ASSEMBLY
1				D3163-041	COVER ASSEMBLY
1				D3163-041	BRACKET ASSEMBLY (ROLLER)
1				D3163-042	BRACKET ASSEMBLY (ROLLER)
1	1			D3203-1	HANDLE ASSEMBLY
2	2			D3208-1	DOUBLER
55	21	21		D3208-2	INSERT (OR SL2052-3-4)
10	10			AN525-10F	SCREW
8	8	4	4	AN525-10F	SCREW
8	8	6	6	AN560UD10	WASHER
18	18	4	4	AN560UD10L	WASHER
13	13	32	32	AN560UD10LL	WASHER
6	6			AN560UD16L	WASHER
6	6			AN560UD20L	WASHER
2	2			AN560UD6L	WASHER
2	2			AN560UD10L	WASHER
10	10	50	50	AN565-4	INSERT
87	87	50	50	AN565-4	RIVET
12	12			FAW4-032	WASHER
6	6			FAW4-032	WASHER
12	12			M7857-24	RIVET (OR CR3213-4-3)
	3	3		M7857-4	RIVET (OR CR3212-4-3)
	2	2		MS20392-1C1	PIN
	7	7		MS20392-2C15	PIN
2	2	2	2	MS20392-2C17	PIN
2	2	2	2	MS20392-2C29	PIN
				MS20392-3C21	PIN
8	8			MS20426A3	RIVET
12	12			M7857-3-4	RIVET
8	5			MS20426A4	RIVET

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
20	20			MS20426AD4	RIVET
	6	6		MS21042L05	NUT
6	6	2	2	MS21042L05	NUT
	5	5		MS21042L3	NUT
4	4			MS21042L4	NUT
4	4			MS21072L3	NUTPLATE
6	6	9	9	MS24685-151	COTTER PIN
4	4			MS24694-C271	SCREW
	2	2		MS24694-C4	SCREW
	4	4		MS24694-C5	SCREW
6	5			MS24694-S5	SCREW
18	18			MS24694-S50	SCREW
	4	4		MS24694-S55	SCREW
	2	2		MS24694-S55	SCREW
	4	4		MS24694-S90	SCREW
	2	2		MS25281-R6	CLAMP
2	2	2	2	MS27039-1-05	SCREW
14	14	12	12	MS27039-1-06	SCREW
13	13	6	6	MS27039-1-08	SCREW
	2	2		MS3203-231	SCREW
				MS35275-233	SCREW
2	2			MS35549-264	NUT
	4	4		MS35565-305	NUT
	2	2		MS35565-325	NUT
	2	3	3	MS31859-7	WASHER
	4	4		NAS1169-10L	WASHER
	14	14		NAS388-8P	SCREW
	15	15		NAS3169P	WASHER
7	7			NAS40004-10	SPACER
6	6			NAS40004-14	SPACER
	2	2		NAS40004-40	SPACER

#### GENERAL NOTES

- 1 FOR ADJUSTMENT OF LOCKING MECHANISM PRIOR TO DOOR ASSEMBLY, SET AT UNLATCH POSITION AND ADJUST SCREW INWARD UNTIL D3124-1/2 HOOK RESTS AGAINST CUTOUT SHOWN IN VIEW A
- 2 IF REQUIRED, NOTCH D3125-1 LEVER (REF) TO CLEAR THE D3124-1 CLEVIS BASE (REF. 2 PLACES) TO ALLOW FOR FULL TRAVEL OF THE LEVER
- 3 HOLES AND PARTS TO BE LOCATED PER DRILLING JGS. E30-2300-01; D3144-17-18-19, U1, U16/U34, D3162-04112 (FOR -01 DOOR ASSY); D3144-17-19-18-19, U1, U16/U34, D3162-04112 (FOR -02 DOOR ASSY); D3144-17-19-18-19, U1, U16/U34, D3162-04112 (FOR -03 DOOR ASSY); D3112-T1A-T2 (FOR -04 DOOR ASSY)
- 4 INSTALL INSERTS PER DART QSI 005. LOCATE TO MATCH HOLE PATTERN OF MATING PARTS
- 5 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6 ALL DIMENSIONS ARE IN INCHES
- 7 IDENTIFY D412-694-01-02-03-04 COOR ASSEMBLIES USING D2721-DECALS

C1 # 06.03.28 ADD OPTION M7857/3-4

C 05.11.23 ADD D3137-045, D3162-043/-044; REMOVE D3137-041; UPDATED NOTES

B 04.10.07 UPDATE DRAWING

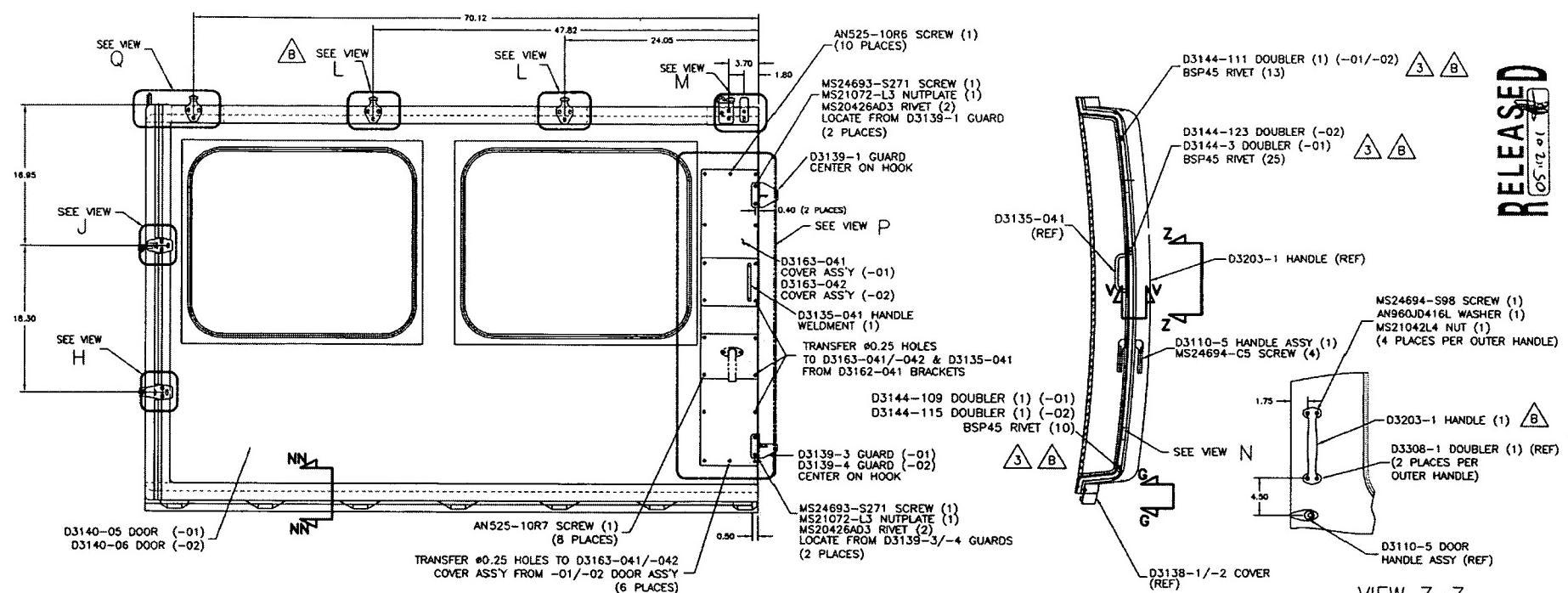
A C2.05.21 NEW ISSUE

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DATE 05.11.23		TITLE DOOR ASSEMBLY	SCALE NTS

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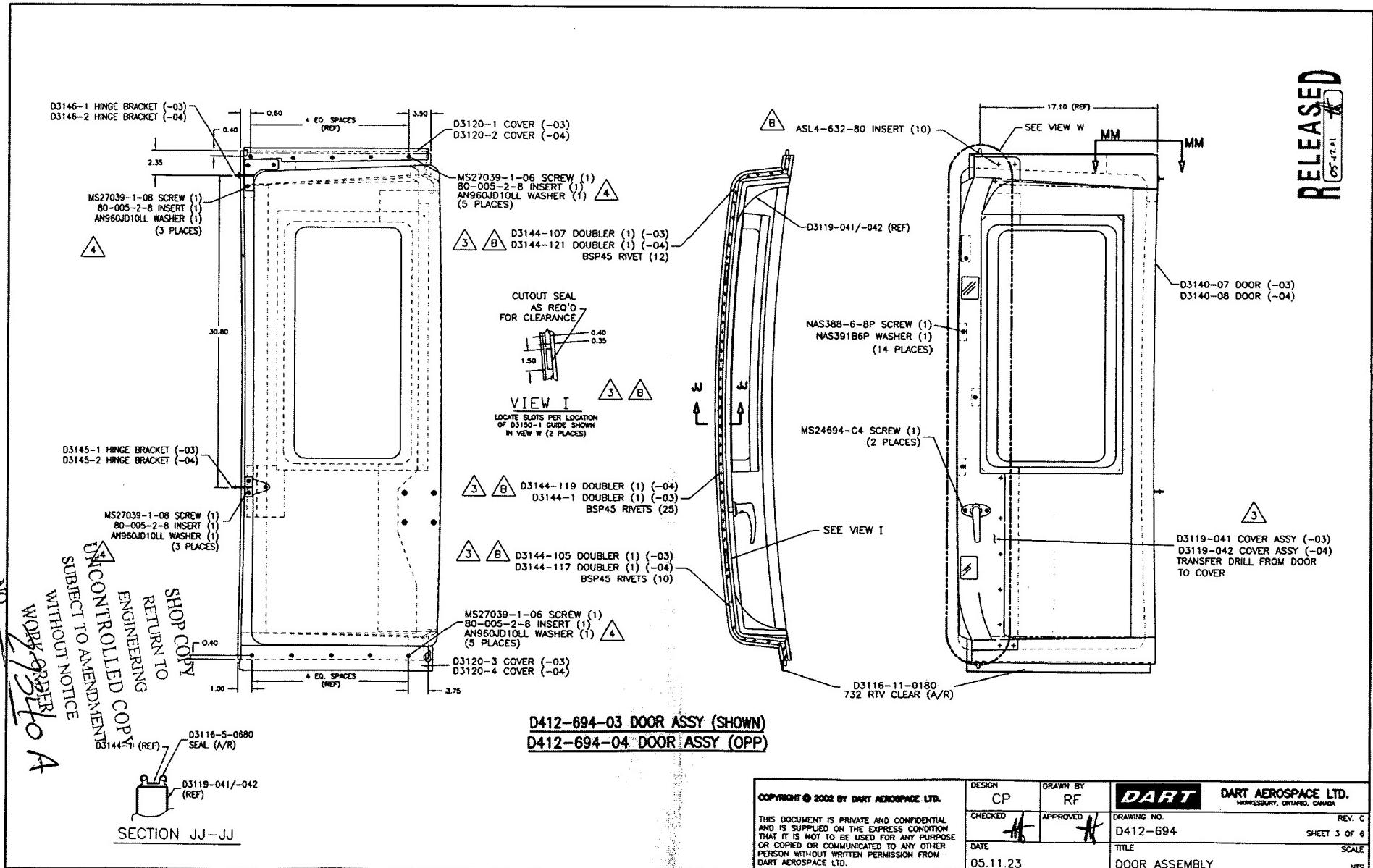
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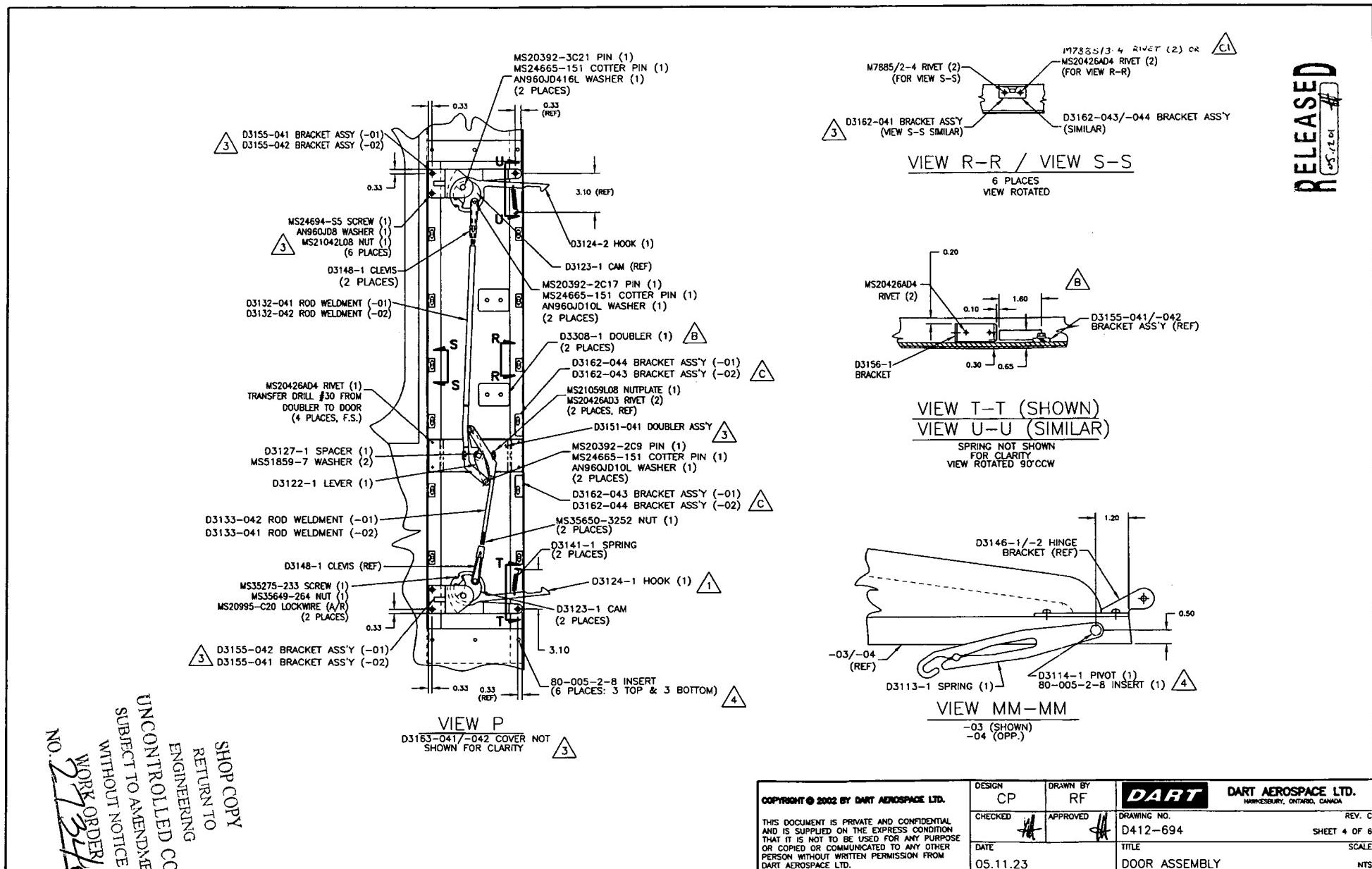


NO. 22  
VIEW G-G  
SUBJ. UNCL. RR  
WORK ORDER 34 A  
NOTICE TO AMENDMENT  
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ENGINEERING COPY  
SUBJ. RR  
TO TURN TO  
SECTION LOCATIONS  
(D3138-4/-5, SHOWN IN SECTIONS)

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CHECKED	APPROVED	DRAWING NO. D412-694	REV. C
DATE 05.11.23		TITLE DOOR ASSEMBLY	SHEET 2 OF 6 SCALE NTS

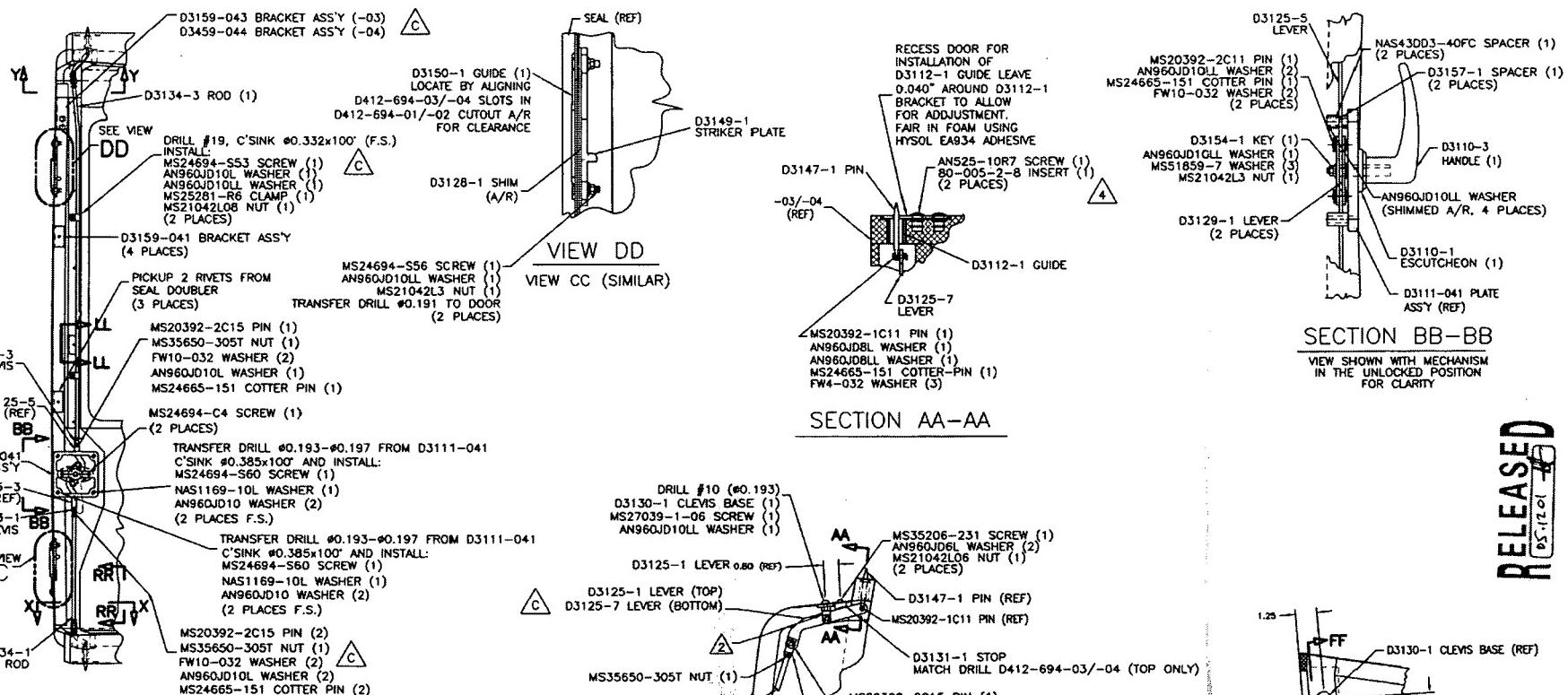
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10-27-12



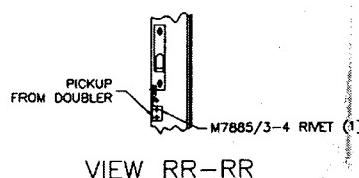


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WORK ORDER NO. 27340 A

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		CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D412-694	REV. C	
		DATE 05.11.23	TITLE DOOR ASSEMBLY		SHEET 4 OF 6	
					SCALE NTS	



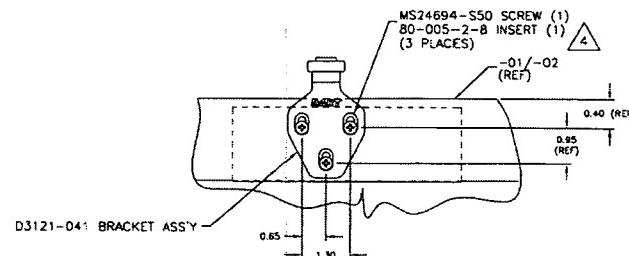
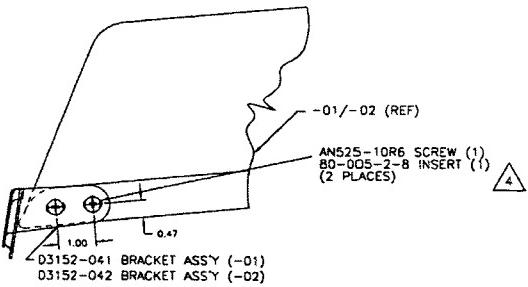
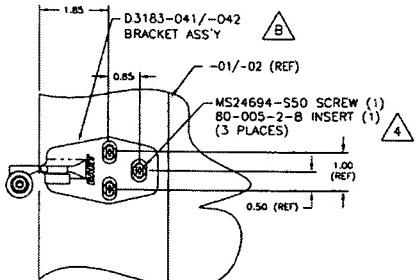
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WITHOUT NOTICE  
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(3 PLACES)  
VIEW ROTATED 90°CCW  
M7885/3-4 RIVET (1)  
(2 PLACES)



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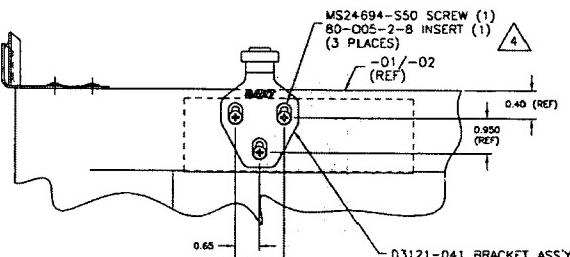
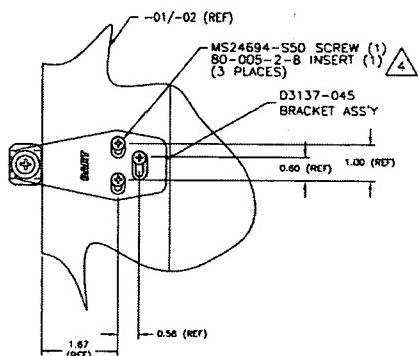
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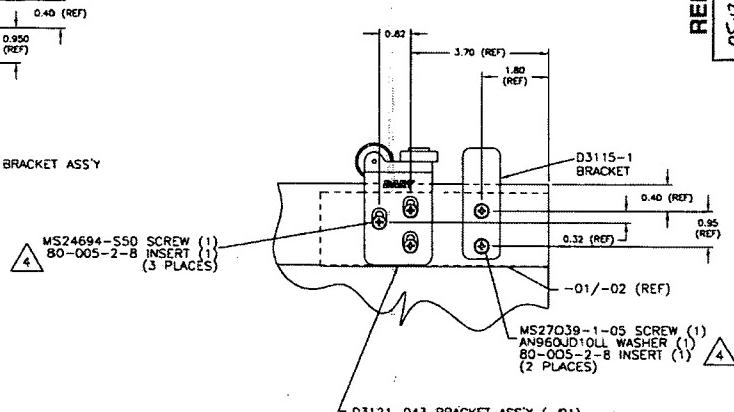


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